

Date: Wednesday, 07/01/2009 1:36:54 PM  
 User: Julie Dawson

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : STA 84 BRACKET  
 Job Number : 44477  
 Estimate Number : 11034  
 P.O. Number :  
 This Issue : 07/01/2009 S.O. No. :  
 Prsht Rev. : NC Part Number : D28031  
 Drawing Number : D2803 REV B  
 Project Number : N/A  
 First Issue : / / Type : MACHINED PARTS Drawing Revision : B  
 Material :  
 Previous Run : 41738 Due Date : 30/01/2009 Qty: 4 Um: Each  
 Written By :  
 Checked & Approved By : JUD 09/01/09  
 Comment : Est. A00.11.06 New Issue EC  
 Est Rev:B Blanks Now Cut on Waterjet 06-06-14 JLM  
 Est Rev:C Removed Tumbling 08-09-10 JLM Verified By:EC

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B0500X10000 6061-T6 Bar .500 x 10.00



Comment: Qty.: 2.0125 f(s)/Unit Total : 8.0501 f(s)

6061-T6 Bar .50" x 10.0"

Material: 6061-T6 bar 10.00" x 0.50"

Batch: 105411X 109288 B 9-1-12

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per template DT8533

Dwg Rev: B B 9-1-12

Prog Rev: B

2-Deburr if necessary

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per folio FA102

mm= 08/01/17

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

mm= 08/01/17

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

SP 09/01/20 (3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2803-1 PAR #: N/A Fault Category: Machining NCR: Yes No DQA: NA Date: 09-01-24  
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: NA Date: 09-01-28

NCR: <u>44477</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/01/17	3.0	All hole not drill at right place because 2nd origin was not well taken human error	GP 09.01.19 per QSI 042	Scrap and destroy and <sup>NO</sup> Replace Qty (1) B105411	mmw 09/01/17	S 09/01/19	GP 09.01.19 per QSI 042	S 09/01/19
09/01/17	3.0	Thickness measure .125 ± .010 is too small due to stock material too small (.488, need 500) and 2nd origin is taken from top of blank	GP 09.01.19 per QSI 042	SCRAP & DESTROY No Replace Qty (40) B105411	mmw 09/01/17	S 09/01/19	GP 09.01.19 per QSI 042	S 09/01/19
		measure 0.107" ± f.c.s No offset was taken to achieve proper thickness operator error.						

NOTE: Date & initial all entries

Date: Wednesday, 07/01/2009 1:36:54 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STA 84 BRACKET

Job Number: 44477

Part Number: D28031

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

MS

09-01-23

(3)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09/01/23 (3)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

09/01/23 (3)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/01/26

Job Completion



MF 09-01-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 44477
<b>Description:</b> Bracket		<b>Part Number:</b> D2803-1
<b>Inspection Dwg:</b> D2803	<b>Rev:</b> B	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.757	+0.005/-0.000	Ø.757	✓			
Ø0.191	+0.005/-0.000	Ø.191	✓			
Ø0.507	+0.000/-0.001	Ø.507	✓			
13.558	+/-0.010	13.556	✓			
Ø0.507	+0.000/-0.001	Ø.506	✓			
12.411	+/-0.010	12.410	✓			
2.654	+0.000/-0.001	2.654	✓			
0.437	+0.000/-0.001	.437	✓			
1.420	+/-0.001	1.420	✓			
6.933	+/-0.010	6.933	✓			
0.250	+/-0.010	.250	✓			
0.875	+0.000/-0.001	.875	✓			
0.250	+0.000/-0.005	.250	✓			
0.125	+/-0.010	.126	✓			
0.125	+/-0.010	.115	✓			
0.125	+/-0.010	.116	✓			
0.125	+/-0.010	.117	✓			
0.500	+/-0.010	.499	✓			
0.562	+/-0.010	.562	✓			
0.188	+/-0.010	.188	✓			

<b>Measured by:</b> mms	<b>Audited by:</b> SP	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 09/01/17	<b>Date:</b> 09/01/20	<b>Date:</b>	N/A

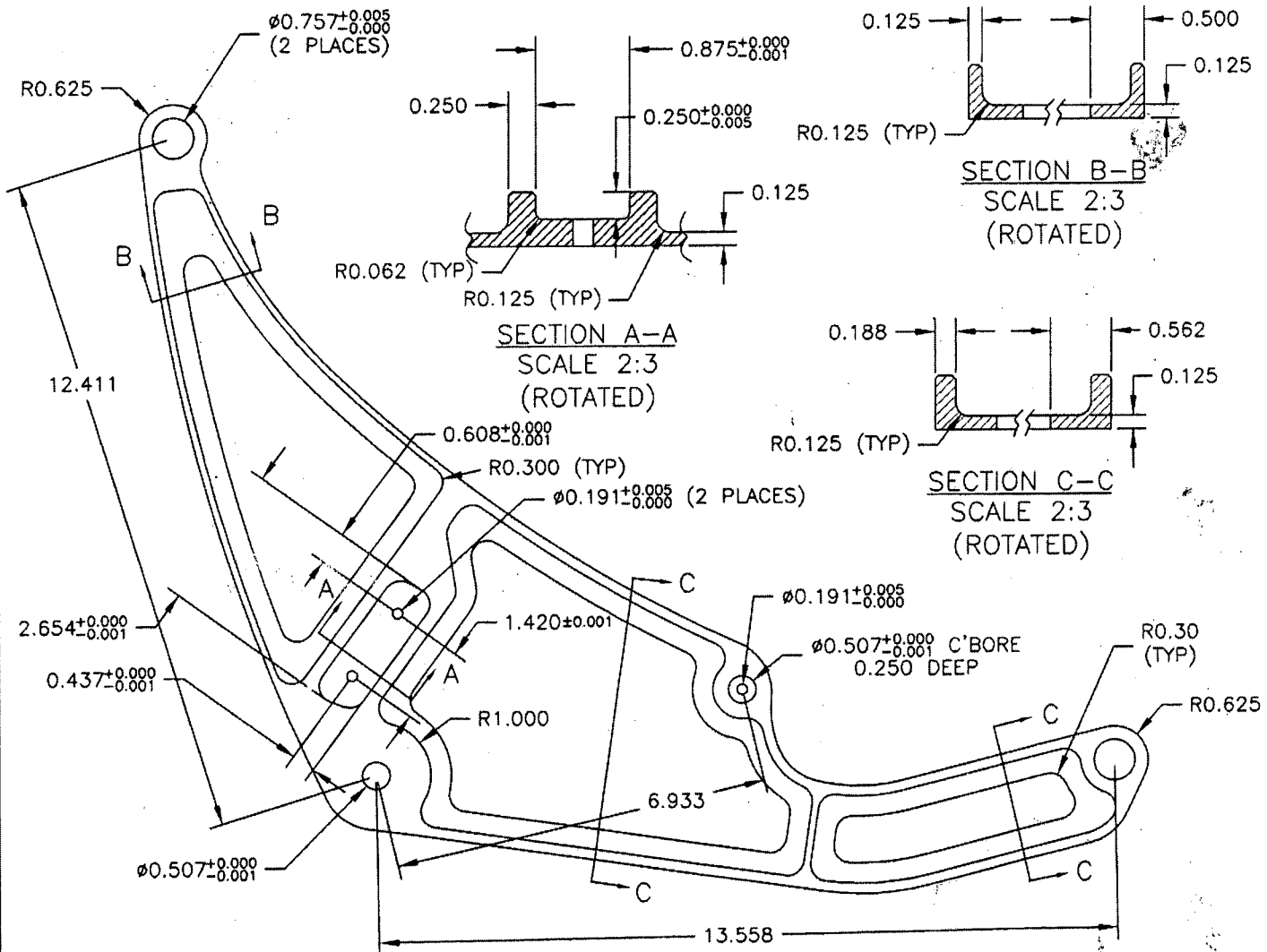
Rev	Date	Change	Revised by	Approved
A	05.04.25	New Issue	KJ/JLM	
B	07.07.18	12.625 dimension removed	KJ/JLM	

**DART**

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD	REV. B
				HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D2803	SHEET 1 OF 2
DATE	04.11.22	TITLE	STA 84 BRACKET	SCALE	1:3
A	00.11.07	NEW ISSUE			
B	04.11.22	ADD CUTOUTS & -043/-044			

**RELEASED**

05.03.11



SHOP COPY  
RETURN TO  
ENGINEERING

**D2803-1 BRACKET (SHOWN). D2803-2 BRACKET (OPPOSITE)**

- 1) MACHINE PER DRAWING FILE "D2803.SLDPR" WITH NOTICE
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WORK ORDER  
NO. *[Signature]*

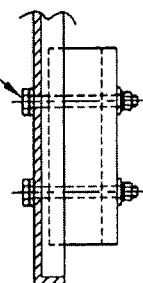
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DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2803	REV. B SHEET 2 OF 2
DATE 04.11.22		TITLE STA 84 BRACKET	SCALE 1:3

AN3C16A BOLT (1)  
NAS1515H3 WASHER (2)  
MS21043-3 NUT (1)  
INSTALL BOLT WITH LPS-3 CORROSION  
INHIBITOR (ENSURE NO LPS-3 ON THREADS)  
(2 PLACES)



SECTION D-D  
SCALE 1:3  
(ROTATED)

USE D2803-1 FOR D2803-041/-043  
USE D2803-2 FOR D2803-042/-044

USE D2805-1 FOR D2803-041  
USE D2805-2 FOR D2803-042  
USE D2805-3 FOR D2803-043  
USE D2805-4 FOR D2803-044  
PRESS INTO PLACE PRIOR TO POWDER COAT

PRESS D2809 INTO PLACE  
PRIOR TO POWDER COAT

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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

RELEASED

05.03.11

D2803-041/-043 BRACKET ASS'Y (SHOWN).  
D2803-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)  
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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